



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4037-1

Job Sheet 202891



Part No: D4037-1

Job Qty: 5 pcs

Part Name: Aft Crossbeam



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/5/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 11/22/19

Description:

Note: DWG REV E IPP REV:A NEW ISSUE 09-12-14 JLM VERIFIED BY:EC IPP REV:B AS PER REV B 10-04-19
JLM VERIFIED BY:EC IPP REV C:AS PER ECN 10-563 10-09-28 JLM VERIFIED BY:DD IPP REV:D AS PER
ECN 11-554 11-05-24 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	5 pcs		11/22/19	0.17	4.46	Waterjet - Flow		2/19/11/30
110	HAAS 4 Axis - B4B	5 pcs		11/22/19	1.00	18.52	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		M.M. 20-01-03
120	QC 2	5 pcs		11/22/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		20-01-03
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		

Plex 11/5/19 10:18 AM Dart.lajeunesse.marie

				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
130 QC 8	5	11/22/19	0.00 0.00	QC 8 - 12	
	pcs			QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
140 Handfinish - 1-1 Chemical- B4B	5	11/22/19	0.00 0.96	Handfinish - 1 - 1 - B4B	
	pcs			Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	

7/20/01/04

SA JAN 06 2020

11/5/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
				Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
				QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 -	

N 235590.

150 Powdercoat - 1 White Gl(A)-B4B

5
pcs

11/22/19

0.00 1.00

START: 8:25 W.T.300° FINISH: 8:55.

160 QC 3

5
pcs

11/22/19

0.00 0.00

BK 20-01-8

DAS
81
9-89

JAN 09 2020

DAS
28
9-89

170 Packaging 3-1 - Stock - B4B

5
pcs

11/22/19

0.00 0.00

					B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
180 QC 21 - SA	5 pcs	11/22/19	0.00	0.00	QC 21 - SA - 21	D48
					QC 21 - SA - 70	21
					QC 21 - SA - 53	3-9

Part Op 100 - Cut blank as per file D4037-1 _BLANK
 Descriptions: 110 - (HAAS CNC Vertical Machine) MACHINE AS PER FOLI FA877 AND DWG
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum)
 160 - (QC3- Inspect Part Finish)
 170 - (Identify as per dwg & Stock Location: _____)
 180 - (QC21- Final Inspection - Work Order Release)

ST642

JAN 13 2020

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X16.000	6061-T6 Bar 1.00 X 16.00	19.5000 ft (3.9 ea)	100-Waterjet - Flow - 1	S232778
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6B1.000X16.000	20	8	0
Part Specifications				
Specifications could not be found.				

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DART AEROSPACE LTD		Work Order: 702891
Description: Aft Crossbeam		Part Number: D4037-1
Inspection Dwg: D4037	Rev: E	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.530	+/-0.010	0.524	✓		gauge Pin	
0.25	+/-0.030	0.256	✓		118-120	Deep throat mic
2.00	+/-0.030	2.003	✓		gauge Block	
2.75	+/-0.030	2.751	✓		SL10 Vern	
1.00	+/-0.030	1.016	✓		"	
R0.032	+/-0.010	0.032	✓		Rad gauge	
42.87	+/-0.030	42.875	✓		edge Finder	
1.38	+/-0.030	1.379	✓		SL10 Vern	
1.750	+/-0.010	1.750	✓			
2.125	+/-0.010	2.125	✓			
2.250	+/-0.010	2.250	✓			
0.875	+/-0.010	0.875	✓			
0.875	+/-0.010	0.875	✓			
6.000	+/-0.010	6.000	✓			
1.125	+/-0.010	1.125	✓			
0.86	+/-0.030	0.865	✓			
1.38	+/-0.030	1.380	✓			
8.04	+/-0.030	8.042	✓			
5.29	+/-0.030	5.292	✓			
Ø0.316	+0.006/-0.001	0.317	✓		gauge Pin	
Ø0.391	+0.006/-0.001	0.391	✓		"	
0.38	+/-0.030	0.376	✓			
7.75	+/-0.030	7.750	✓			
R0.63	+/-0.030	0.630	✓		Rad gauge	
R1.00	+/-0.030	1.000	✓		"	
	DAS					

Measured by: 20 9-89	Checked by:	QC Inspector:
Date: 20-01-02	Date:	Date:

Engineering Approval: (if necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	10.06.08	New Issue	KJ	
B	11.06.21	Dwg Rev updated	KJ	
C	17.07.13	Dimensions updated per Dwg Rev E	KJ	

Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____		DISPOSITION		DEPARTMENT/PROCESS		Engineering	
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	
Date: _____		Sequence #: _____		Skid-tube Machining ☐ Large Fab ☐		Water Jet ☐ Supplier ☐ Quality ☐	
Description Work Order Deviation				QTY Affected: _____			
Disposition				MRB (QS1042)			
				Completed By _____			
				Lead hand / Supervisor _____			
QC / QA Coordinator _____							
Root Cause		FAULT CATEGORY					
Operator ☐		Pressure/Forced ☐		Contamination ☐		Power Loss/Surge ☐	
Manufacturing Process ☐		Bending ☐		Misaligned/off center ☐		Folio/Program ☐	
Equip/Tooling ☐		Crushing ☐		BOM/Route ☐		Grain Direction ☐	
Handling/Preservation ☐		Cracks ☐		Broken/Damage/Defect ☐		Weld ☐	
Material ☐		Crimp/Kink/Ripple/Wave/Twist ☐		Incomplete/Unclear Instructions ☐		Wrong Stock Pulled ☐	
Product Improvement ☐		Marks/Chatter ☐		Drill Holes ☐		Out of Sequence ☐	
Process Improvement ☐		Mislabeled ☐		Fit/Function ☐		Off-set/Set-up ☐	
Human Factors ☐		Other/Details: _____				Positioned Wrong ☐	
						Outside Tolerance ☐	
						Drawing ☐	
						Finish ☐	
						Part Lost/Missing ☐	
						Misread ☐	